






Work Order ID 70777




Wednesday, June 15, 2011 9:10:22 AM







Page 1

Item ID: D3189-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Chafing Shield
Start Date: 6/15/2011 Start Qty: 20.00  Cust Item ID:
Required Date: 6/22/2011 Req'd Qty: 20.00  Customer:

Reference:

Approvals: Process Plan:  Date: 6-15-11 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3189	Rev B								
100	SHEAR	0.00							
 Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev:  Prog Rev:  2-Deburr if necessary								
304 . 020									
103	QC2- Inspect parts off machine FAI/FAIB	0.00							
 QC	Memo	0.00							
Quality Control									

RB 11-6-29



RB 11-6-29

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Item ID: D3189-1

Accept

Revision ID:

Item Name: Chafing Shield

Start Date: 6/15/2011 Start Qty: 20.00

Required Date: 6/22/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

105

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

110

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Deburr & Grind Rads as per Dwg D3189
2-Roll as per Dwg D3189

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

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Item ID: D3189-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Chafing Shield

Start Date: 6/15/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/7/68 221

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/68

ms
61-07-06

Picklist Print

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Page 1

Work Order ID: 70777

Parent Item: D3189-1

Parent Item Name: Chafing Shield



Start Date: 6/15/2011

Required Date: 6/22/2011



Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B 05.08.22 No longer made in-house KJ/JLM
 IPP Rev:C 06-03-24 Rolling Now made in House JLM
 IPP Rev:D 07-04-16 As per Rev B JLM
 11.05.11 now made on waterjet DD verf:JLM

IPP Rev:E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA 		Purchased	No			100	sf	22.0000	0.32	6.736842	7.		
304/316 .020" Sheet											BL-6-29		

Location

MAT20

117285

Loc Qty

22

22

Loc Code

117285

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08	NEW ISSUE	
B	07.01.05	ADD -3	

RELEASED

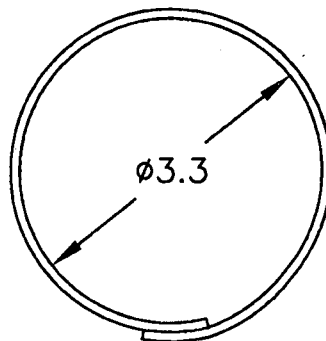
07.03.27 [Signature]

11.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70777

PL 11-06-15

4.13

D3189-1 FLAT PATTERNR0.063
(TYP)D3189-1 ROLLING DETAIL
NOT TO SCALED3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

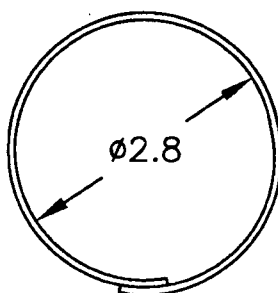
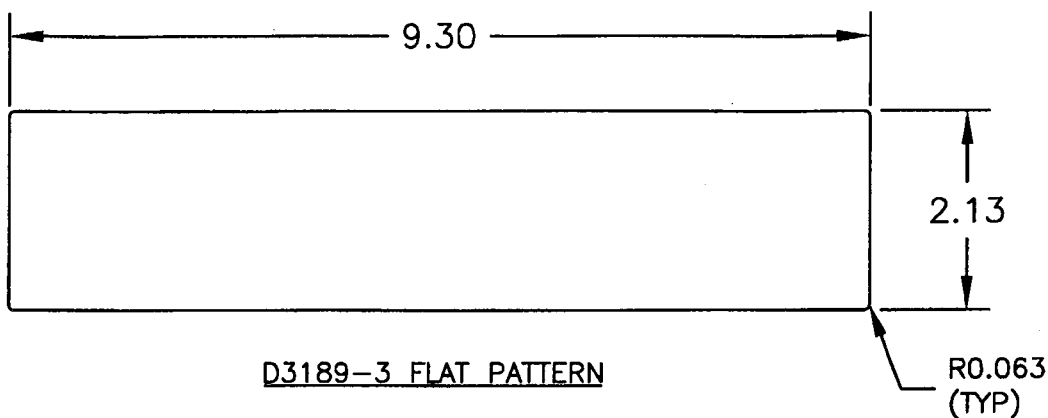


DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

RELEASED

07.03.27 *[initials]*

w/0 76777



D3189-3 ROLLING DETAIL
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
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